

24

Date: Wednesday, 5/23/2007 3:30:47 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L/L3/L4 HIGH GEAR SKID
 Job Number : 32495
 Estimate Number : 10525
 P.O. Number : N/A Part Number : D206642411
 This Issue : 5/23/2007 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A
 Previous Run : 32394 Material : N/A
 Written By : Due Date : 6/15/2007 Qty: 1 Um: Each
 Checked & Approved By : KS 07-05-24
 Comment : Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JL
 M

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



KS 07-05-30

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-411 CHG004

2/E 07/08/27

2.0

32495A

206 L HIGH GEAR SKIDTUBE



Comment: Sub-Component 206 L HIGH GEAR SKIDTUBE

D206-642-441 B 32495A

6/8/27 SP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0

D2652

Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

24 D2652

Bushing

B 33215

1 D206-642-441(REF)

32495

6/8/27 SP

5.0

D2655

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2655

Tow Ring

B 332280

6/7/08/230

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:30:48 PM
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Process Sheet

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Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 32495

Part Number: D206642411



Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2659

Lug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2659 Lug Assembly

B32018 (14)

~~532~~ 29780 (14) -

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

10 D2712

Set Screw

B32506 (91)

B33667 (14) -

8.0

D29321

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2932-1

Saddle

B33654 -

9.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2933-1

Saddle

B32022 -

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

B33235 -

11.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

B33219 -

CP 09/08/230

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 32495

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29381

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2938-1

Saddle

B33355

13.0

D29391

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2939-1

Saddle

B34145

59 7/8/25

14.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2968-043

Tow Ring

B30275

15.0

AN337A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN3-37A

Bolt

M102339

16.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN3-41A

Bolt

M104156

17.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

CP 07/08/2007

W/O:		WORK ORDER CHANGES					
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Job Number: 32495

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

1 AN4-5A
AN46A

Bolt M100857-
Bolt



CP

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt M105057-

19.0

AN511A

Bolt



CP

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN5-11A

Bolt M104746-

20.0

AN512A

Bolt



CP

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-12A

Bolt M104106-

21.0

AN513A

Bolt



CP

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-13A

Bolt M15928-

22.0

AN960JD10

Washer



CP

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN960JD10

Washer M104885-

CP 07/08/220

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 32495

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part Number

Description

Batch

1 AN960JD1016

Washer

M15519 -

24.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

Qty Part Number

Description

Batch

25 AN960JD416

Washer

M104215 -

25.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number

Description

Batch

+2 8 AN960JD516

Washer

M1054156 -

26.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part Number

Description

Batch

1 AN970-4

Washer

M103344 -

27.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Qty Part Number

Description

Batch

12 MS21042L3

Nut (or -3)

M104936 -

28.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Qty Part Number

Description

Batch

13 MS21042L4

Nut (or -4)

M103914 -

EP 7/18/220

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 32495

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Er 07/08/27

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-411

Location:

PPP Rev:

32495 A

7/8/28 SP

31.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

12/10/28

Job Completion



6 07/08/28

B 32495 A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:31:34 PM
 User: Kim Johnston

Process Sheet

24

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE
 Job Number : 32495A
 Estimate Number : 10522
 P.O. Number : N/A Part Number : D206642441
 This Issue : 5/23/2007 S.O. No. : N/A Drawing Number : D2650 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : E
 Previous Run : 32396A Material : N/A
 Written By : Due Date : 6/15/2007 Qty: 1 Um: Each
 Checked & Approved By : *JD 07.05.24*
 Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JL
 M

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

2.0

D2620

Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2620

Bent Tube 3" OD

B32754

3.0

D2647

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2647

Fwd Cap

D2932B BE 07-06-14

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R

Aluminum Rod

*M102421/M103**104305**BE**07-06-14*

4-Grind weld flush to cap on top surface only.

*BE 07-06-14**JD 7-6-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 32495A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end 138.60" from front of tube *Pm 07-07-240*

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312". *Pm 07-07-240*

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Pm 07-07-250



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

D26547

206 I Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

B31789 07/07/25 / R M

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: *07/07/25* Time: *2:10*

Finish Date: *07/27/25* Time: *2:25*

A/R Sikaflex-291

Sikaflex expiry date: *01/2008*

AWM 07/07/25 / R

Pm 0707-250

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 32495A

Part Number: D206642441

Job Number:



Seq. #: Machine Or Operation: Description :

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 07-07-28

9.0 D2649 Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick:

Qty Part Number Description Batch
23 D2649 Crossbolt spacer

3-31926 BE 07-07-28

10.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod m 104221 BE 07-07-28

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

) R 7-7-30

11.0 D2680041 Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2680-041 Nut Plate

1328935 DP 2-7-31

12.0 CCR264SS33 Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 CCR264SS3-3 Rivets

103525 DP 2-7-31

13.0 M7885343 Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

DP 2-7-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 32495A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 M7885/3-4-3

Rivets

19099

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



P10 →

Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

DP

2-2-31

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/01

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/01

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



IX

Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-A

07/08/15

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

M 105008

BR/M-A 07-08-15

①

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/08/20

20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

1332465

MS

21.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

1331113

MS

07-08-20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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07/07/01	#14	He wrong rivets were pulled from stock (M7885/3-4) and installed in nut plate. R.C. wrong rivet was placed in Box also Hummer Error	<i>[Signature]</i> 05/08/02	Drill out rivets and replace with correct M7885/3-4 M# B19099 - investigate why wrong rivets were placed in wrong Box	<i>[Signature]</i> 7-7-01	Er 07/08/02	<i>[Signature]</i> 07/08/02	Er 07/08/01

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 32495A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

22.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe B30940

MH

23.0

D265637

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe B33217

MH

24.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad B30237

MH

25.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts M1102475

or (see QSI 017)

MH

26.0

AN960JD10L

Washer



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer M1104885

MH

07-08-20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 32495A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS27039108

Screw



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 MS27039-1-08

Screw M104603

JK

28.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs B32576

JK

29.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings B32099

JK

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer M103338

JK

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw M15194

JK

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

B31335

JK 07-08-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:31:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 32495A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2646

Aft Cap _____

33.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer

M104885

MS

34.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw

M104603

MS

35.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

M104989

Sikaflex expiry date:

08-01

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650.

Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

M104989

Sikaflex expiry date:

08-01

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: M104942

FL 07/08/21 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:31:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 32495A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/02/22

37.0

QC5

INSPECT WORK TO CURRENT STEP



All Plugs
in tube

Comment: INSPECT WORK TO CURRENT STEP

En 07/08/22

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/8/22 SP

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 08.08.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>UP</i>	DRAWN BY <i>P</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES SCALE NTS	
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

RELEASED
06 04 17 *H*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

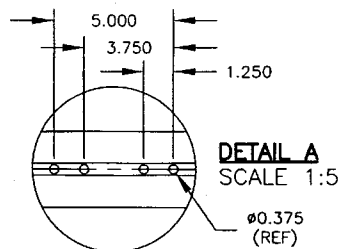
NOTES

- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH:
-CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

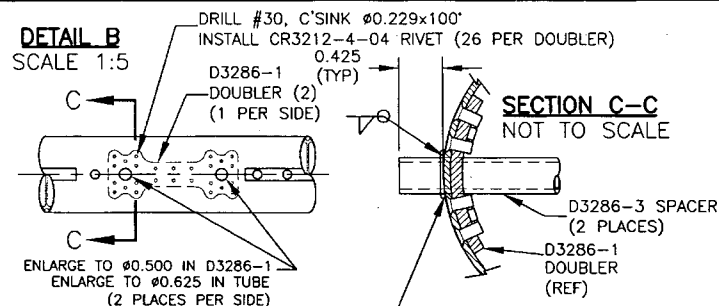
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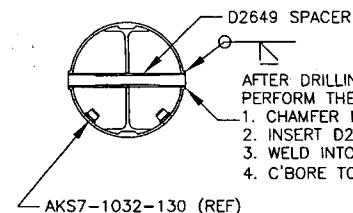
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
32495A



DETAIL B
SCALE 1:5



SECTION C-C
NOT TO SCALE



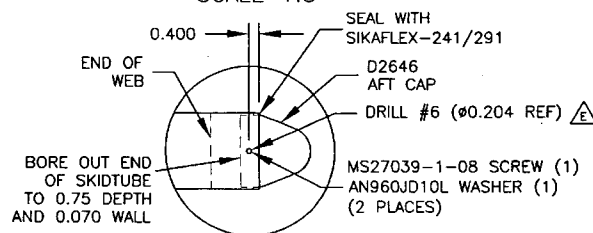
DETAIL D
FOR 0.375 HOLES ONLY

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO 0.313 X 0.75 DEEP

RELEASED

06.04.07

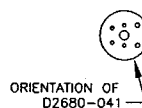
DETAIL E
SCALE 1:5



DETAIL F (NOT TO SCALE)

- CUT TUBE LEVEL
- REMOVE RIDGE ON FWD SIDE
- LOCATE D2647 (TRIM AS NECESSARY)
- WELD D2647 IN PLACE PER DART QSI 004
- GRIND FLUSH
- RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN
D2680-041 PRIOR TO
FINISH



REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

TO
32495A
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY


D2650-1 BENDING/DRILLING DETAIL

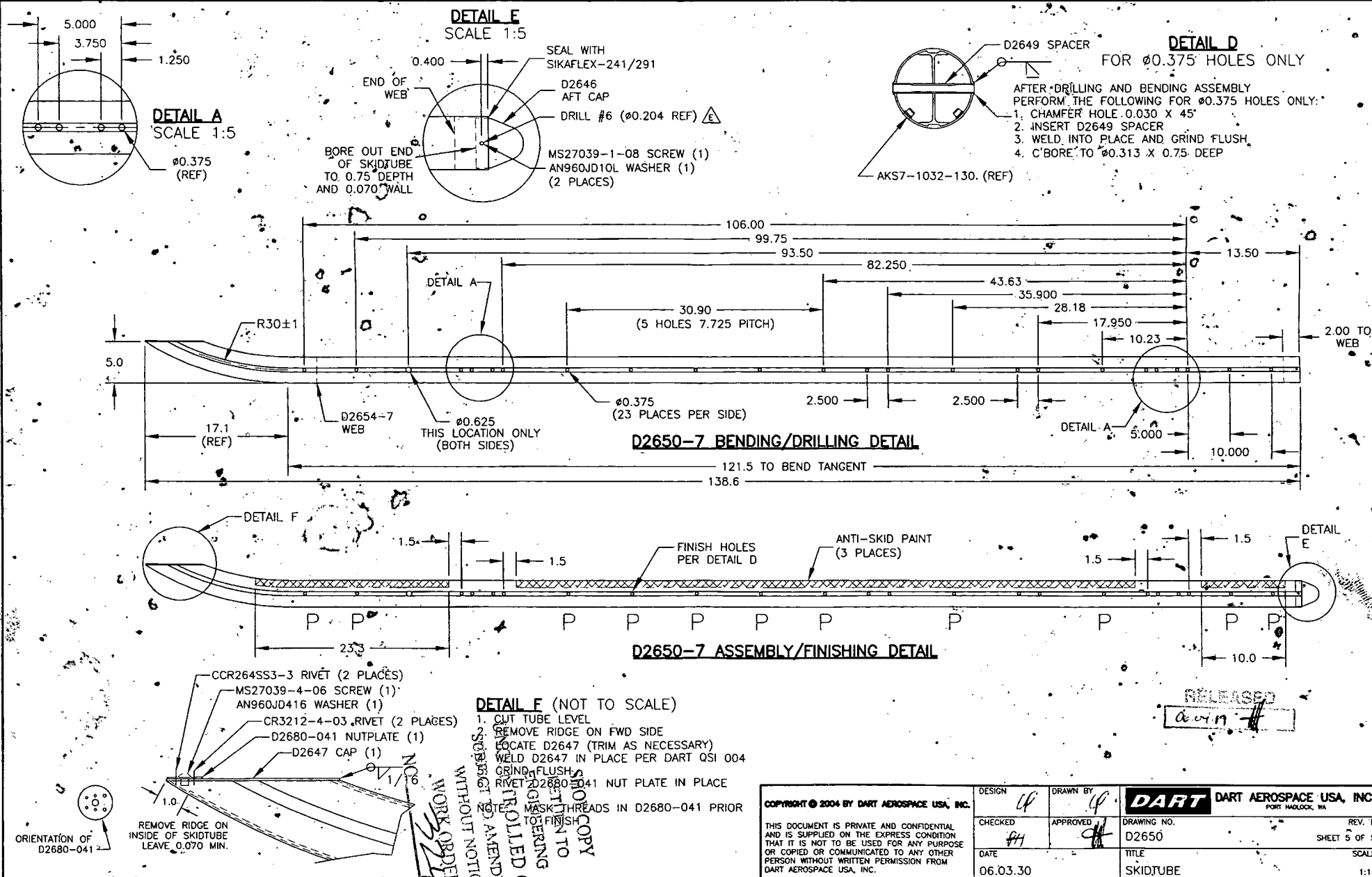
D2650-1 ASSEMBLY/FINISHING DETAIL

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DESIGN	CP	DRAWN BY	CP	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. E
CHECKED	PH	APPROVED	H	DRAWING NO. D2650	SHEET 2 OF 5
DATE	06.03.30	TITLE	SKIDTUBE	SCALE	1:10

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	CHECKED	APPROVED		DRAWING NO.	REV. E
	DATE				SHEET 3 OF 5
	42 PH	42 [Signature]	D2650	SCALE 1:10	
	06.03.30		SKIDTUBE		



DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
REMOVE RIDGE ON FWD SIDE
LOCATE D2647 (TRIM AS NECESSARY)
WELD D2647 IN PLACE PER DART QSI 004
GRIND FLUSH
RIVET D2680-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D2680-041 PRIOR
TO FINISH

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DESIGN

14

CHECKED

54

DATE 11/1

06 03 30

DRAWN BY

1

APPROVED	
----------	--

10

Figure 1 shows a horizontal number line. A point labeled 'a' is marked at the origin (0). To the right of 'a', there is a point labeled 'b'. To the right of 'b', there is a point labeled 'c'. The distance between 'a' and 'b' is indicated by a bracket and labeled 'a'. The distance between 'b' and 'c' is indicated by a bracket and labeled 'b'.

• 4

DART DART AEROSPACE USA, INC
ROSE, MARYLAND, USA

DRAWING NO.	REV.
-------------	------

D2650 SHEET 5 OF 5

TITLE	SCALE
-------	-------

SKIDTILBE

NO. 120

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number 206642541 / 033621A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

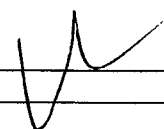
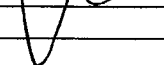
The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/07/30

Qualifier Barclay Elliott

Date: Thursday, 11/10/2007 2:26:44 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-642
Job Number : 35132	
Estimate Number : 10804	
P.O. Number :	Part Number : Z_CUSTOM
This Issue : 11/10/2007 S.O. No. :	Drawing Number : ECN 1046-PAPERWORK
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LANDING GEAR	Drawing Revision :
Previous Run : 00015	Material :
Written By : 	Due Date : 18/10/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 REMOVE FROM STOCK:

D206-642-111 15614 15615
 D206-642-112 10319 25504
 D206-642-141 9575 18613
 D206-642-211 33078 32559-32565-33795-33776
 D206-642-212 32257 32567-32568-32568-33079-33080-33242
 D206-642-213 19735
 D206-642-214 24414-24484-28083-29084-32983-32984
 D206-642-241 28097-28604-33211-33342
 D206-642-311 28847
 D206-642-312 29741-15619-29742-29744
 D206-642-341 2-15619-29741
 D206-642-341 34557-34056-34555-34556-32495-31980
 D206-642-411 34132
 D206-642-411BL 34564-34563-34562-34060-34059-32502-34058
 D206-642-412 34135
 D206-642-412BL 34135
 D206-642-441 31066-30940-30260-30265-24739
 D206-642-511 34582-34579-33848-34581
 D206-642-512 34586-34584-34583
 D206-642-513
 D206-642-514
 D206-642-541
 D206-642-611
 D206-642-612

ADD NEW PAPERWORK EASA.IM.R.S.01320 REV.1
 PER ECN 1046

1-11-07 SP